

GREEN

Dart Aerospace Ltd.

Date: Wednesday, 9/6/2006 3:46:08 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number :	28446		
Estimate Number :	10533		
P.O. Number :	N/A	Part Number :	D2573
This Issue :	9/6/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2573 REV E
First Issue :	N/A	Project Number :	N/A
Previous Run :	27994	Drawing Revision :	E
	Type :	Material :	N/A
	MACHINED PARTS	Due Date :	9/13/2006
Written By :			Qty: 6 Um: Each
Checked & Approved By :	[Signature]		
Comment :	Est: As For RevE 06-01-27 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2573
 Ensure that grain is along 7.75" length
 Batch No: D 25354

Er 06/09/13 x6

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 27994/6 Double check by: JL

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

m/Er 06/09/13

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

m 06/09/13

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

m 06/09/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 06/10/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/6/2006 3:46:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 28446

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

M8

06/09/22

6

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

J. a. m.

06/09/27 X6

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat GREEN (Ref: 4.3.5.1) as per QSI 005 4.3

J.

06/10/05

~~06/09/28~~ X6

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P. G. 10/6

(6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 11/0003

P. G. 10/6

(E)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

P. G. 10/06

Job Completion



W 06-10-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 28446
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.749	1.749	1.749		
C	3.495	3.505		3.500	3.506	3.500	3.506		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.006	8.005	8.005	8.006		
F	0.490	0.510		0.502	0.501	0.502	0.501		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.502	0.501	0.499	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.567	0.566	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.121	4.120	4.122	4.122		
P	0.115	0.135		0.124	0.124	0.129	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.254	0.253	0.253	0.253		
S	0.115	0.135		0.118	0.117	0.118	0.117		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.241	0.241	0.241		
W	0.115	0.135		0.119	0.120	0.122	0.129		
X	0.308	0.313		0.309	0.309	0.309	0.310		
Y	0.760	0.765		0.766	0.760	0.760	0.760		
Z	0.352	0.372		0.368	0.367	0.368	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.629	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.248	0.249	0.251		
AE	1.500	1.520		1.514	1.513	1.513	1.513		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.260	0.260	0.260	0.266		
AH	0.240	0.260		0.250	0.251	0.251	0.251		
AI	2.000	2.020		2.004	2.004	2.003	2.003		
AJ	0.023	0.043		0.035	0.035	0.035	0.035		
Accept/Reject									

Measured by:	ML
Date:	06/09/19

Audited by:	MB
Date:	06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 28446
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

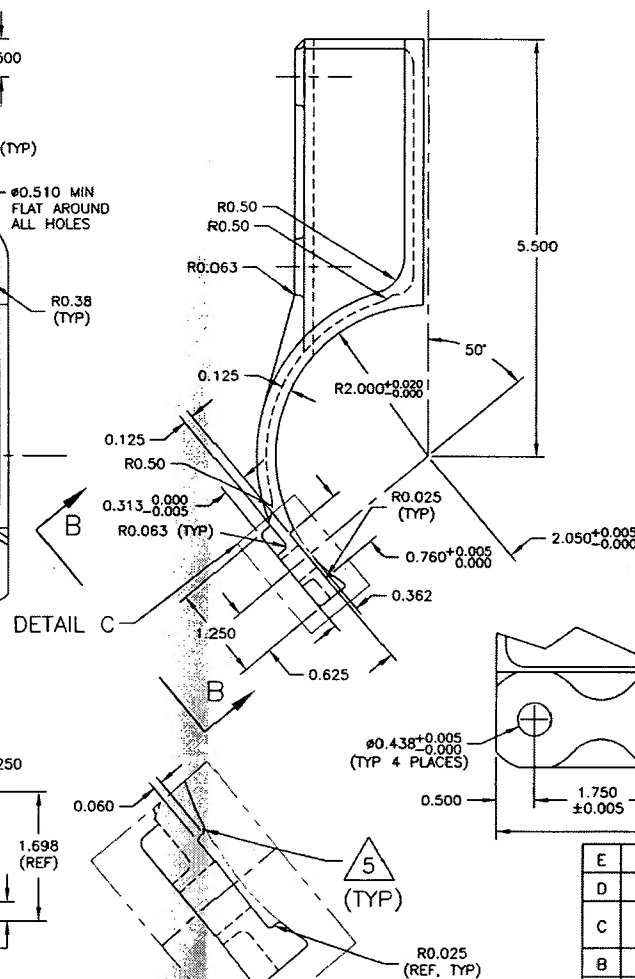
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	✓	✓				
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N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.121	4.122				
P	0.115	0.135		0.125	0.125				
Q	0.115	0.135		0.135	0.135				
R	0.240	0.260		0.254	0.253				
S	0.115	0.135		0.120	0.118				
T	0.178	0.198		0.188	0.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		0.241	0.241				
W	0.115	0.135		0.128	0.128				
X	0.308	0.313		0.310	0.310				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.367	0.367				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.625	0.627				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.250	0.249				
AE	1.500	1.520		1.511	1.510				
AF	0.115	0.135		0.125	0.125				
AG	0.240	0.280		0.260	0.260				
AH	0.240	0.260		0.251	0.251				
AI	2.000	2.020		2.002	2.000				
AJ	0.023	0.043		0.035	0.035				
Accept/Reject									

Measured by:	gml
Date:	06/09/18






Audited by:	MB
Date:	06/09/18

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A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06



MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |

DETAIL C
SCALE 4:3

SECTION A-A

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 28446

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN	DRAWN BY	NEW ISSUE	
DS	PH	DART	DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2573	REV. 1 SHEET 1 OF 2
DATE 05.07.13	TITLE OUTER AFT SADDLE		SCALE 2: